

ABSTRACT

With a split-type vulcanizing mold, a proper clamping force of the mold is obtained without carrying out shim adjustment. A lower washer (16), disc springs (17), and an upper washer (18) are inserted into each of a plurality of cylindrical holes (15) defined on the circumference of a spacer ring (14). A spacer ring (14) provides an outer ring (8) with a pre-load so as to be tightened up by a bolt (12), so that the outer ring (8) can be smoothly moved without backlash in the axial direction thereof all the time. Selection is made on the disc springs (17) having a load such that a proper clamping force is obtained when a deflection of the disc springs (17) is equivalent to half a deflection at the time of the maximum load of the disc springs (17), and regardless of whether variation in dimensions, at the time of fabricating the mold, is on the plus side or minus side, the variation in dimensions is absorbed to thereby clamp the respective sector molds (6) with a proper clamping force. As the sector molds (6) are caused to undergo reduction in diameter, the spacer ring (14) is pushed down by the bolster plate (9) to thereby descend, causing the disc springs (17) to undergo gradual deflection, so that the clamping force applied to the sector molds (6) is increased.